

Monday, 10/22/2007 3:41:44 PM

Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEBBING TIDY
Job Number	: 35283		
Estimate Number	: 11381	Part Number	: D32153
P.O. Number	: <i>N/A</i>	Drawing Number	: D3215 REV D
This Issue	: 10/22/2007 S.O. No. : <i>N/A</i>	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: D
First Issue	: <i>N/A</i> Type : SMALL / MED FAB	Material	: <i>N/A</i>
Previous Run	: 30614	Due Date	: 11/5/2007 Qty: 60 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i> 07.10.23		
Comment	: Est. A 04.01.06 New issue KJ/RF		
	: Est Rev:B Now on Waterjet 06-07-03 JLM		
	: est rev C ecn 940 07.06.12 EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



2.0867



Comment: Qty.: 0.0271 sf(s)/Unit Total : 1.6254 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S.040)

Identify for D3215-3A

Batch: *101875* *HB 07-10-25*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3215 (D3215-3A)

Dwg Rev: *D* *HB 07-10-25*Prog Rev: *D*2-Deburr if necessary *20* *8/3* *07/10/29* *(77)*

3-Identify as D3215-3A

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*HB 07-10-25*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK *5* *07/10/23* *(77)* *counted*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:41:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-BAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 35283

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

M5052H32S040

5052-H32 .040 Sheet



Comment: Qty.: 0.0084 sf(s)/Unit Total: 0.5040 sf(s)

5052-H32 .040 Sheet

Batch: M102723

FF 07-10-29

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D3215-3B (2.130" x 0.530") as per dwg D3215

FF 07-10-29

2-Deburr

FF 07-10-29

3-Identify as D3215-3B

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

cauter
S 07/10/29 (477)

8.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

SB 07/10/30

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

cauter
S 07/10/30 (477)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

A/R AL ROD BATCH: M104855

Identify as D3215-3

Grind flush FL 07/11/01

SD 07/10/31

(74X)

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SD 07-11-01

(66)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	10						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/11/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/01	10	8 parts ground too much After welding, and with thinner material, the weld was removed. Use scrap RC: Human error. Small parts, thin material.	<u>FC</u> 07/10/01	scrap, destroy.	<u>FC</u> 07/10/01	<u>FC</u> 07-10-11	<u>FC</u> 07/10/01	<u>FC</u> 07-11-01

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:41:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 35283

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

07/11/01 (66)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-11-01 (66)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 102314

07-11-01

(66)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/11/01

(66x)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

07/11/02

(66)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/02

(66)

Job Completion



07.10.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

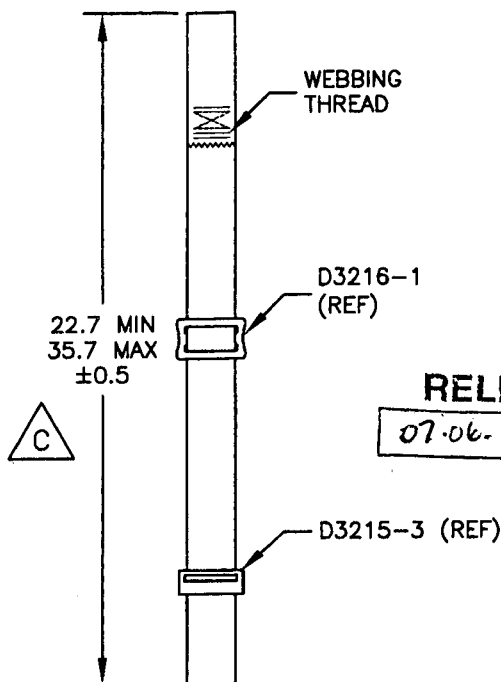
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

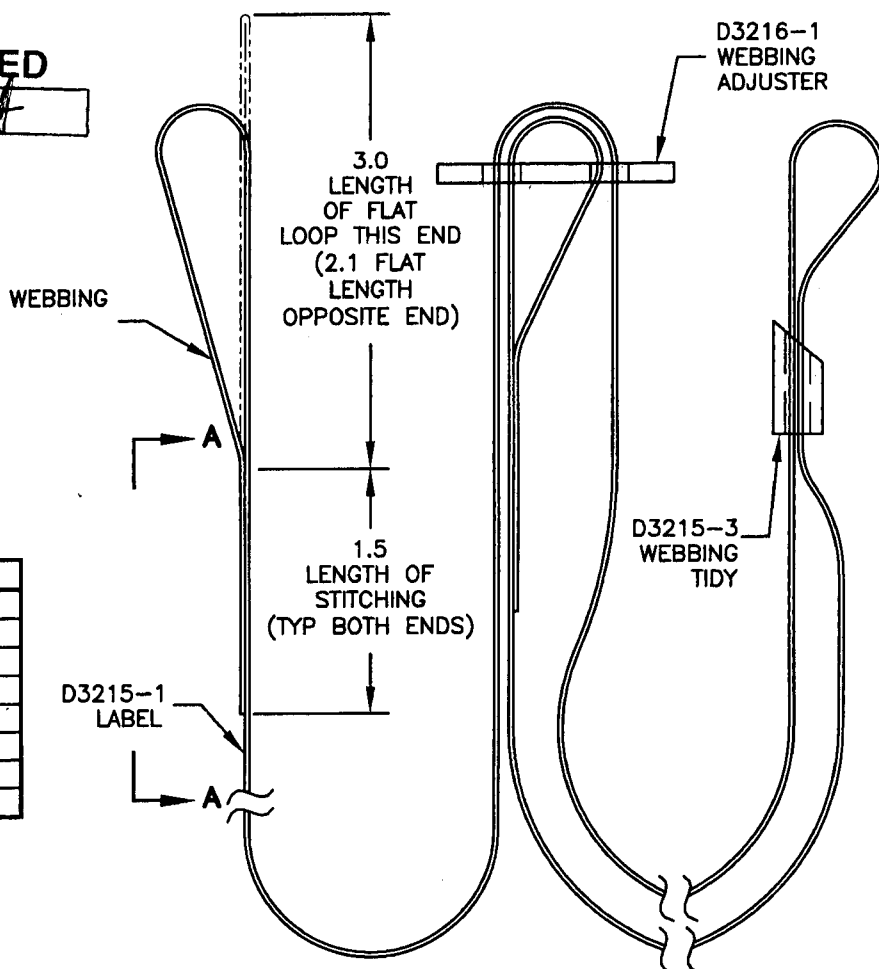


DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3215	REV. D SHEET 1 OF 3
DATE 07.03.27	TITLE BELT ASSEMBLY	SCALE NTS	
A	03.09.19	NEW ISSUE	
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE	
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING	
D	07.03.27	ADD WEBBING SUPPLIER; ADD LABEL THREAD AND MATERIAL; IN VIEW A-A, 1.4 WAS 1.8; ADD -3A AND -3B; UPDATE TOLERANCES	



PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3215-041	BELT ASSEMBLY
AS REQ'D	SEE NOTE 1	WEBBING
AS REQ'D	SEE NOTE 1	WEBBING THREAD
AS REQ'D	SEE NOTE 1	LABEL THREAD
1	D3215-1	LABEL
1	D3215-3	WEBBING TIDY
1	D3216-1	WEBBING ADJUSTER



D3215-041 BELT ASSEMBLY:

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN
OR BELT TECH CANADA INC. 27039, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 6000 lb MIN
WEBBING THREAD = V-T-295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL THREAD = V-T-295 TYPE II CLASS A SIZE F, BLACK NYLON THREAD

- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) SEE SHEET 3 FOR VIEW A-A



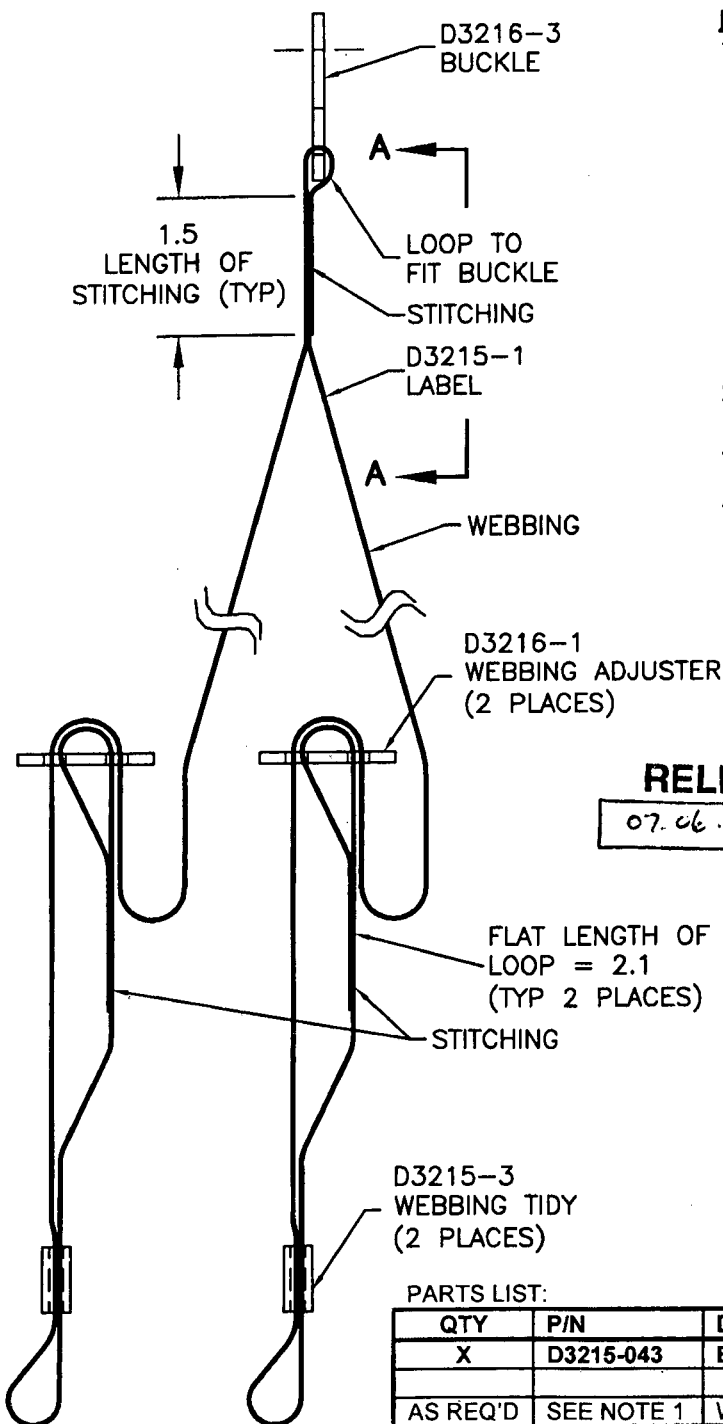
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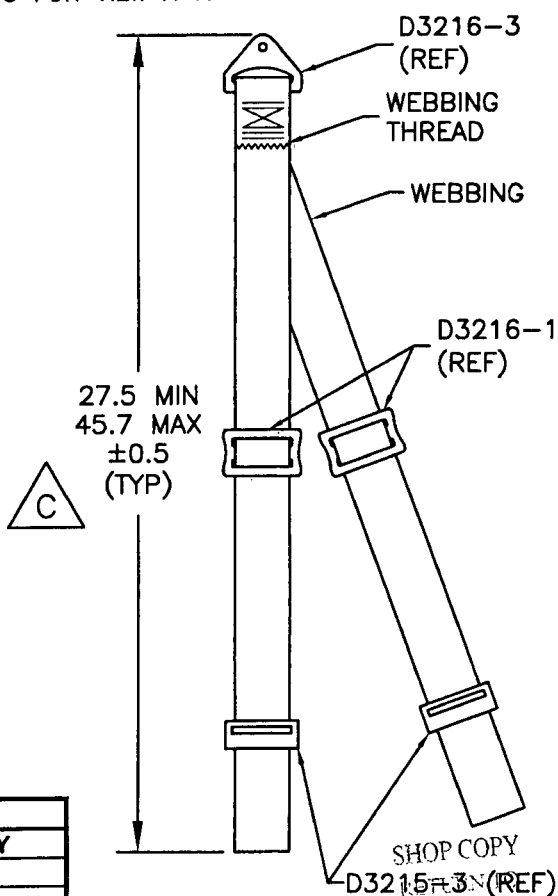
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CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3215	REV. D SHEET 2 OF 3
DATE 07.03.27		TITLE BELT ASSEMBLY	SCALE NTS



D3215-043 BELT ASSEMBLY:

- 1) MATERIAL:
WEBBING = LAGRAN CANADA INC. 26472, 1.8 WIDE
x 0.05 THICK BLACK POLYESTER WEBBING,
CERTIFIED TO FAR 29.853A3, TENSILE
STRENGTH 5700 lb MIN
OR BELT TECH CANADA INC. 27039, 1.8 WIDE
x 0.05 THICK BLACK POLYESTER WEBBING,
CERTIFIED TO FAR 29.853A3, TENSILE
STRENGTH 6000 lb MIN
WEBBING THREAD = V-T-295 TYPE II CLASS A SIZE 3,
BLACK NYLON THREAD
LABEL THREAD = V-T-295 TYPE II CLASS A SIZE F,
BLACK NYLON THREAD

- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) SEE SHEET 3 FOR VIEW A-A

RELEASED
07.06.07 *H*



PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3215-043	BELT ASSEMBLY
AS REQ'D	SEE NOTE 1	WEBBING
AS REQ'D	SEE NOTE 1	WEBBING THREAD
AS REQ'D	SEE NOTE 1	LABEL THREAD
1	D3215-1	LABEL
2	D3215-3	WEBBING TIDY
2	D3216-1	WEBBING ADJUSTER

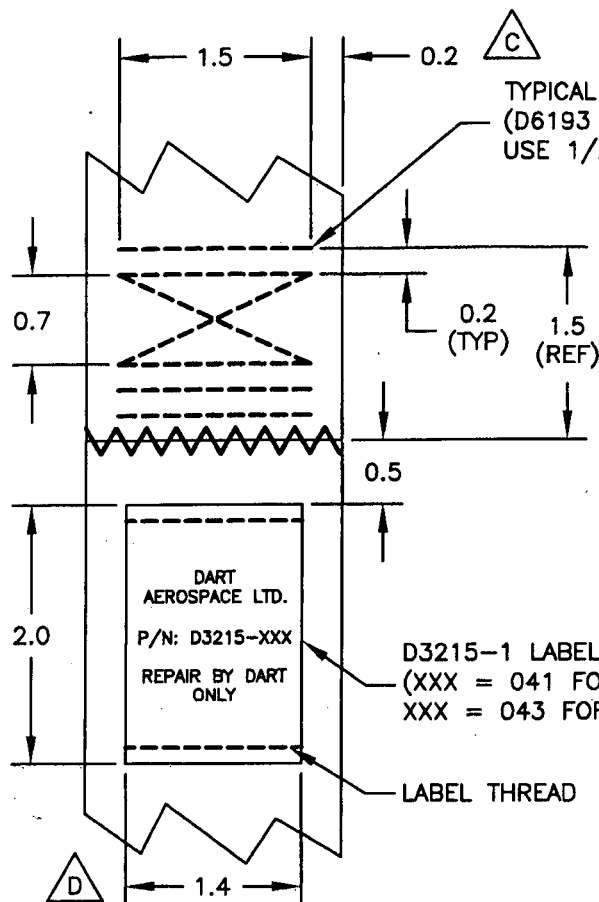
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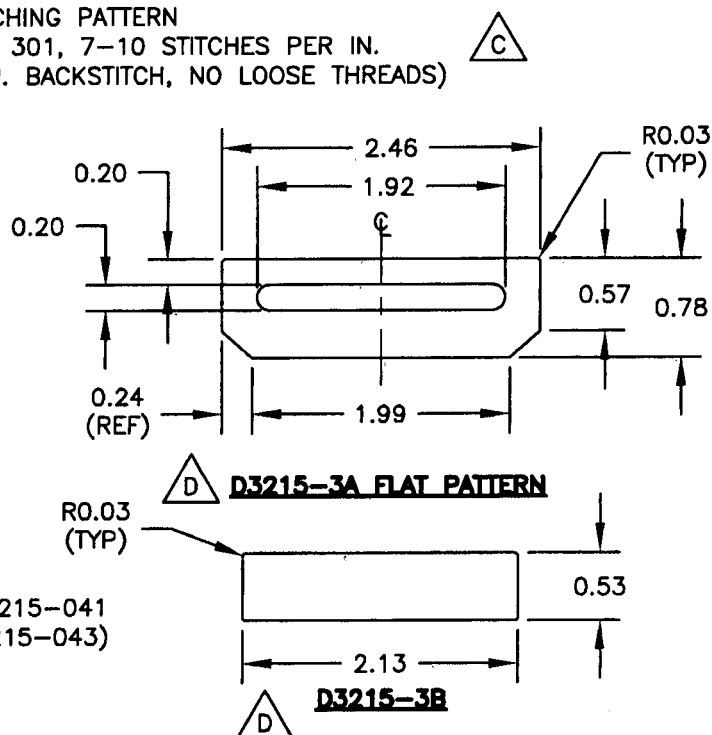
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CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3215	REV. D SHEET 3 OF 3
DATE 07.03.27		TITLE HARNESS ASSEMBLY	SCALE 3:2



VIEW A-A



D3215-3A/-3B NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC. M5052H32S.040)
- 2) BEND D3215-3A PER D3215-3

D3215-1 LABEL:

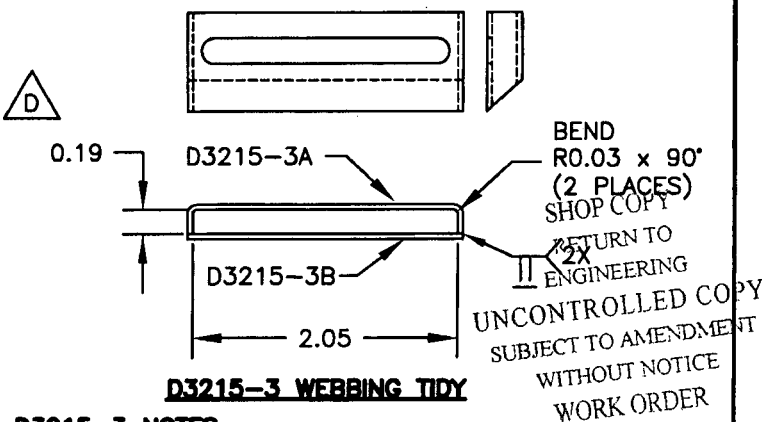
- 1) MATERIAL: WHITE TYVEK OR WHITE POLYESTER WHICH MEETS FMVSS 302
- 2) USE 1/8 BLACK LETTERING
- 3) CENTER ON BELT WIDTH

RELEASED

07.06 07-*[Signature]*

GENERAL NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED



D3215-3 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

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